

Grizzly *Industrial, Inc.*®

MODEL G0622 4" x 6" METAL CUTTING BANDSAW OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
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#PC8472 PRINTED IN CHINA

 **WARNING!**

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

 **WARNING!**

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Foreword

We are proud to offer the Model G0622 4" X 6" Metal Cutting Bandsaw. This machine is part of a growing Grizzly family of fine metalworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0622. It was written to guide you through assembly, review safety considerations, and cover general operating procedures.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0622 as supplied when the manual was prepared. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete.

Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
% Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0622 4" X 6" METAL CUTTING BANDSAW

Product Dimensions:

Weight 144 lbs.
Length/Width/Height 16 x 39 x 19 in.
Foot Print (Length/Width)..... 13-3/4 x 19-3/4 in.

Shipping Dimensions:

Type Cardboard
Content..... Machine
Weight 148 lbs.
Length/Width/Height..... 17-3/4 x 21-1/2 x 37 in.

Electrical:

Switch..... Automatic Shut-Off
Switch Voltage 110V
Cord Length 8-1/2 ft.
Cord Gauge 16 gauge
Recommended Breaker Size 15 amp
Plug Yes

Motors:

Main

Type..... TEFC Capacitor Start Induction
Horsepower 3/4 HP
Voltage..... 110V
Prewired 110V
Phase Single
Amps 5A
Speed..... 1725 RPM
Cycle 60 Hz
Number Of Speeds 1
Power Transfer V-Belt & Gear Drive
Bearings Shielded and Lubricated

Main Specifications:

Operation Information

Blade Speeds..... 78, 108, 180 FPM
Standard Blade Length 1/2 x 0.028 x 64-1/2 in.



Cutting Capacities

Angle Cuts	0-60°
Vise Jaw Depth	6-1/2 in.
Vise Jaw Height	3-1/4 in.
Max. Capacity Rectangle Height at 90°	6 in.
Max. Capacity Rectangle Width at 90°	6 in.
Max. Capacity Round at 90°	6 in.
Max. Capacity Rectangle Height at 45°	4-1/2 in.
Max. Capacity Rectangle Width at 45°	4 in.
Max. Capacity Round at 45°	4-1/2 in.
Max. Capacity Rectangle Height at 60°	2-1/2 in.
Max. Capacity Rectangle Width at 60°	2-1/2 in.
Max. Capacity Round at 60°	2-1/2 in.

Construction

Table Construction	Cast Iron
Stand Construction	Pre-Formed Steel
Body Construction	Aluminium Cast
Wheel Construction	Cast Iron
Base Construction	Cast Iron
Paint	Urethane Hammerstone

Other

Wheel Size	7-3/8 in.
Blade Guides Upper	Ball Bearing
Blade Guides Lower	Ball Bearing

Table Information

Table Length	10-1/4 in.
Table Width	6-3/4 in.
Table Thickness	1-1/4 in.
Floor To Table Height	33 in.

Other Specifications:

Country Of Origin	China
Warranty	1 Year
Serial Number Location	ID on Body Frame
Assembly Time	25 minutes

Features:

- Horizontal and Vertical Operation
- Automatic Shut-Off
- 3/4 HP Motor
- Work Stop



Identification

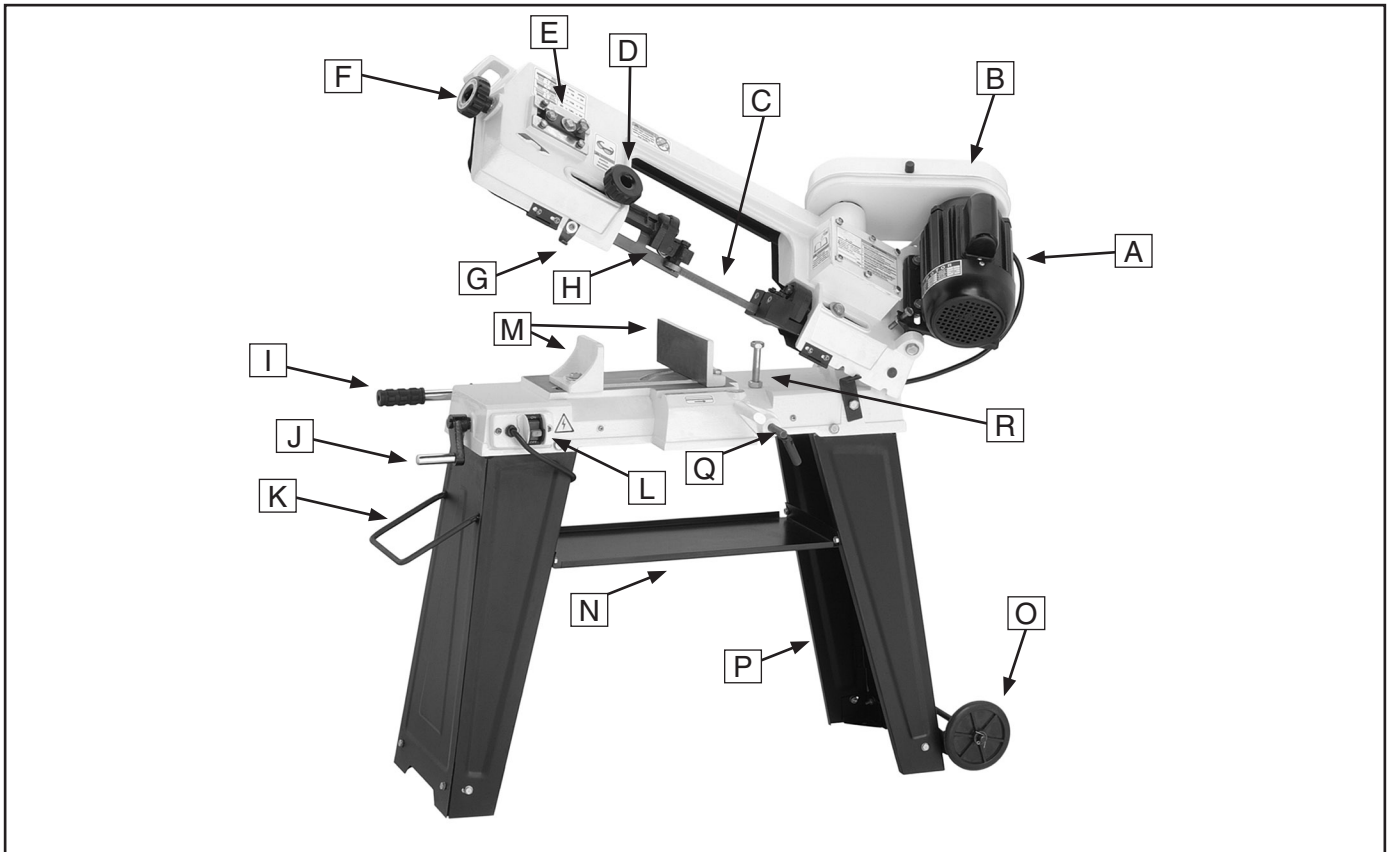


Figure 1. Model G0622 controls and features.

- A. Motor
- B. Pulley Cover
- C. Blade
- D. Blade Guard Adjustment Knob
- E. Blade Tracking Mechanism
- F. Blade Tension Knob
- G. Auto Off Tab
- H. Blade Guide Bearing Assemblies
- I. Feed Adjustment Handle
- J. Vise Crank
- K. Stand Handle
- L. Power Switch
- M. Vise Jaws
- N. Tool Tray
- O. Stand Wheels
- P. Stand
- Q. Work Stop
- R. Horizontal Stop



SECTION 1: SAFETY

WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING

Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **BE AWARE THAT CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Make sure you know the hazards associated with the type of dust you will be exposed to and always wear a respirator approved for that type of dust.



WARNING

Additional Safety Instructions for Metal Cutting Bandsaws

- 1. BLADE CONDITION.** Do not operate with dull, cracked or badly worn blade. Inspect blades for cracks and missing teeth before each use.
- 2. HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Hands could be crushed in vise or by falling machine components or cut by the blade.
- 3. ENTANGLEMENT HAZARDS.** Do not operate this bandsaw without blade guard in place. Otherwise, loose clothing, jewelry, long hair and work gloves can be drawn into working parts.
- 4. BLADE REPLACEMENT.** When replacing blades, make sure teeth face toward the workpiece. Wear gloves to protect hands and safety glasses to protect eyes.
- 5. WORKPIECE HANDLING.** Always support the workpiece with table, vise, or other support fixture. Flag long pieces to avoid a tripping hazard. Never hold the workpiece with your hands during a cut.
- 6. LOSS OF STABILITY.** Unsupported workpieces may jeopardize machine stability and cause the machine to tip and fall, which could cause serious injury.
- 7. POWER INTERRUPTION.** Unplug machine after power interruption. Machines without magnetic switches can start up after power is restored.
- 8. ATTENTION TO WORK AREA.** Never leave a machine running and unattended. Pay attention to the actions of others in the area to avoid unintended accidents.
- 9. MAINTENANCE/SERVICE.** All inspections, adjustments, and maintenance are to be done with the machine **OFF** and the power disconnected to the machine. Wait for all moving parts to come to a complete stop.
- 10. HEARING PROTECTION & HAZARDS.** Noise generated by blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time and interfere with communication and audible signals. Always wear hearing protection.
- 11. HOT SURFACES.** Due to friction, the workpiece, chips, and some machine components can be hot enough to burn you.
- 12. STARTING POSITION.** Never turn the saw **ON** with the blade resting on the workpiece.
- 13. EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.

WARNING

No list of safety guidelines can be complete. Every shop environment is different. Like all machines there is danger associated with the Model G0622. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.



SECTION 2: CIRCUIT REQUIREMENTS

110V Operation

!WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

Amperage Draw

The Model G0622 motor draws the following amps under maximum load:

Motor Draw 5 Amps

Circuit Recommendations

We recommend using a dedicated circuit for this machine. You **MUST** connect your machine to a grounded circuit that is rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

110V Circuit..... 15 Amps

Plug/Receptacle Type

Included Plug Type NEMA 5-15

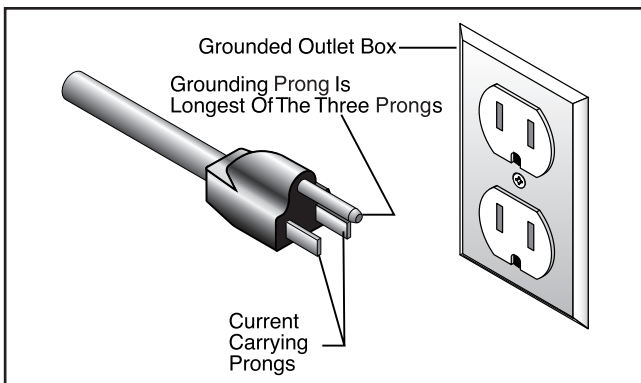

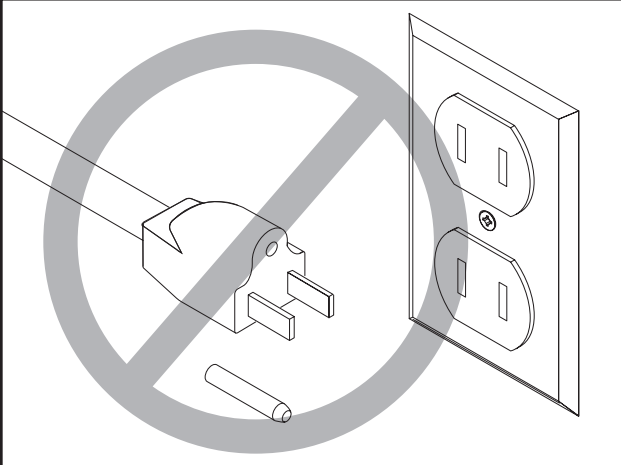


Figure 2. Typical type 5-15 plug and receptacle.



!WARNING

Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!



!CAUTION

This machine must have a ground prong in the plug to help ensure that it is grounded. **DO NOT** remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.

Extension Cords

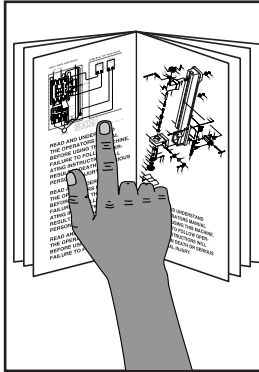
We do not recommend the use of extension cords, but if you find it absolutely necessary:

- Use at least a 16 gauge cord that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician **MUST** size cords over 50 feet long to prevent motor damage.

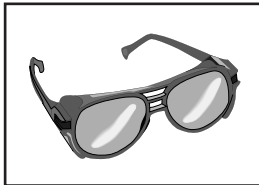


SECTION 3: SET UP

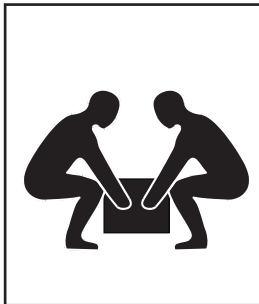
Set Up Safety



!WARNING
This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



!WARNING
Wear safety glasses during the entire set up process!



!WARNING
The Model G0622 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

Items Needed for Set Up

The following items are needed to complete the set up process, but are not included with your machine:

Description	Qty
• Safety Glasses (for each person)	1
• 12mm Open End Wrench.....	1
• 14mm Open End Wrench.....	1
• Sawhorses.....	2
• Helper for Lifting.....	1
• Cleaning Supplies	1
• Pliers	1
• Phillips Head Screwdriver #2	1
• Straightedge, 12" Minimum.....	1

Unpacking

The Model G0622 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.



Inventory

After all the parts have been removed from the two boxes, you should have the following items:

Box 1: (Figure 3)	Qty
A. Bandsaw (not shown).....	1
B. Stand Legs	2
C. Tool Tray	1
D. Corner Support Braces	4
E. Wheels	2
F. Axle	1
G. Wheel Mounting Bracket	1
H. Work Stop Rod.....	1
I. Work Stop.....	1
J. Transport Handle.....	1
K. Pulley Cover	1
L. V-Belt.....	1
M. Pulleys w Keys	2
N. Table	1
O. Table Support.....	1

Hardware Bag (not shown)

- Hex Wrench 4mm (Work Stop) 1
- Hex Bolt M8-1.25 x 20 (Saw to Stand) 6
- Hex Nut M8-1.25 (Saw to Stand) 6
- Flat Washer 8mm (Saw to Stand)..... 6
- Lock Washer 8mm (Saw to Stand) 6
- Hex Bolt M6-1 x 12 (Stand)..... 8
- Phillips Head Screw M6-1 x 12 (Tray) 4
- Hex Nut M6-1 (Stand, Tray, Table)..... 13
- Flat Washer 6mm (Stand, Tray)..... 12
- Fender Washer 6mm (Table)..... 1
- Flat Head Screw M6-1 x 10 (Table)..... 1
- Cotter Pins (Axle & Handle) 4

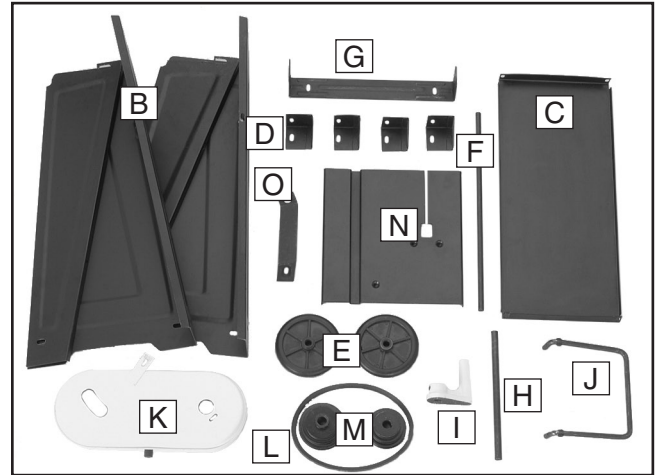


Figure 3. Model G0622 Inventory.

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

NOTICE

Some hardware/fasteners on the inventory list may arrive pre-installed on the machine. Check these locations before assuming that any items from the inventory list are missing.

	<p style="text-align: center;">! WARNING</p> <p>SUFFOCATION HAZARD! Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.</p>
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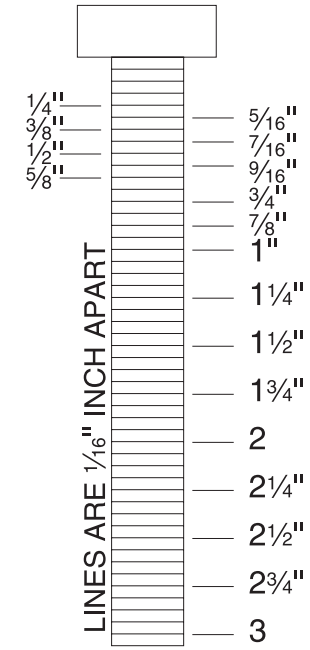
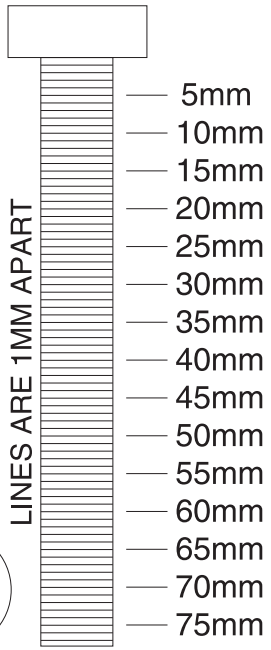
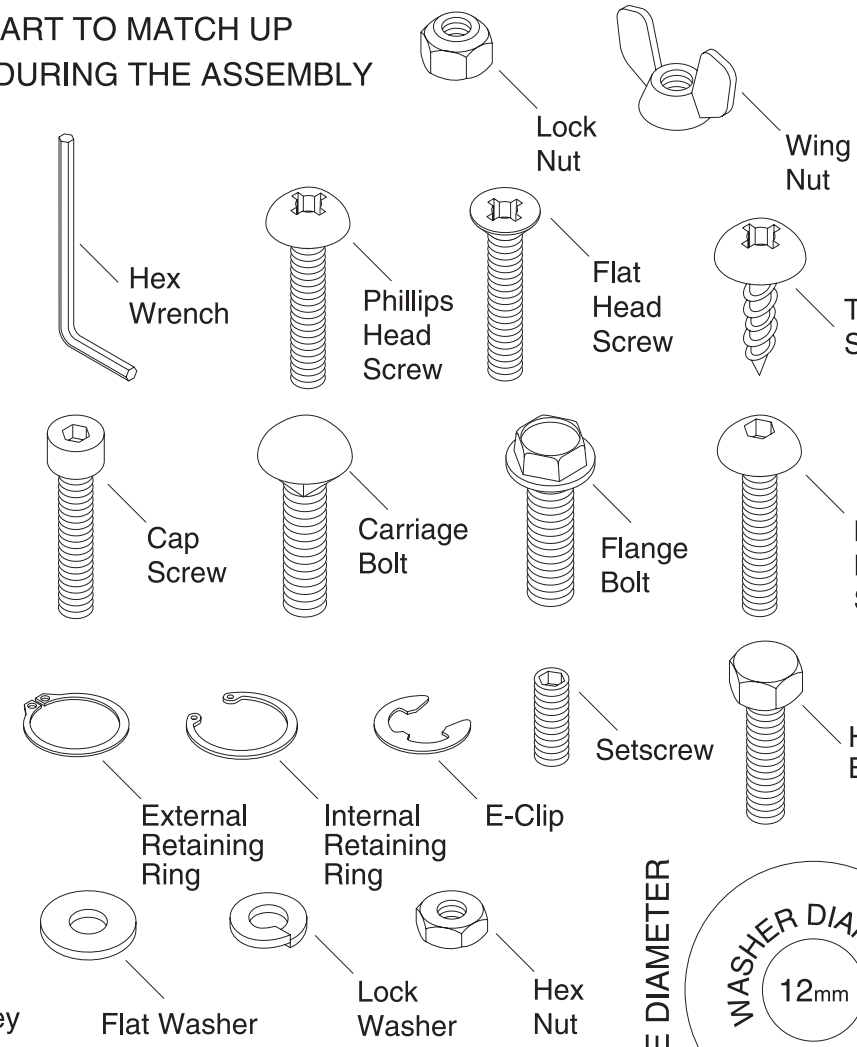
Hardware Recognition Chart

USE THIS CHART TO MATCH UP
HARDWARE DURING THE ASSEMBLY
PROCESS!

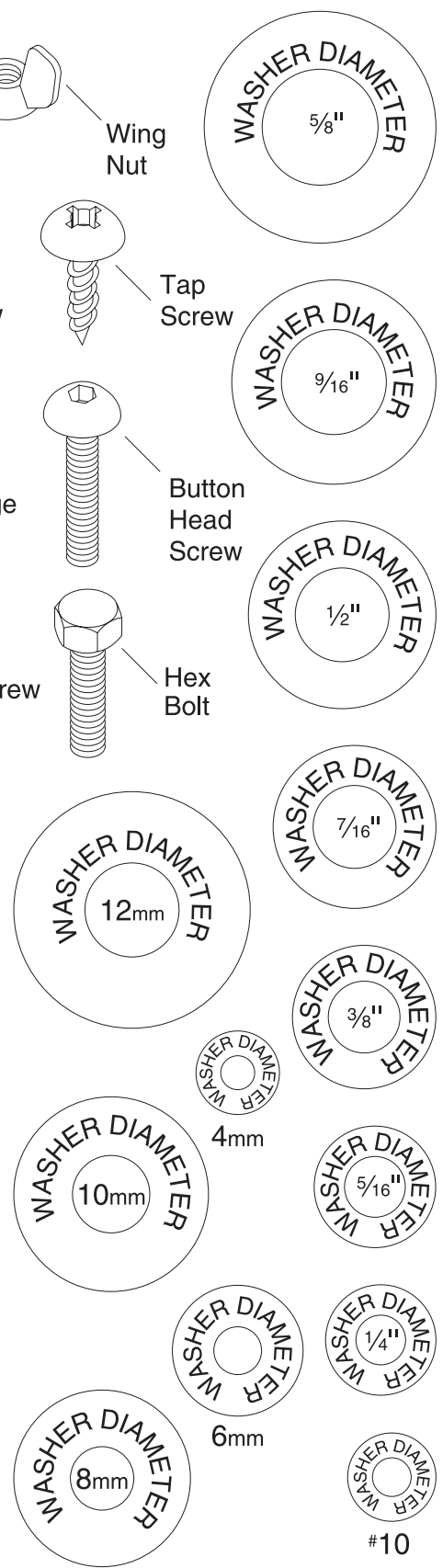
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"

- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm




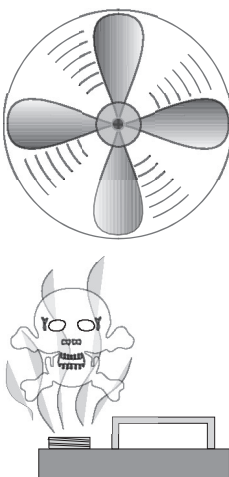
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner, as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

	<p>⚠️ WARNING Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.</p>
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	<p>⚠️ CAUTION Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.</p>
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Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some floors may require additional reinforcement to support both the machine and operator.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 4** for the minimum working clearances.

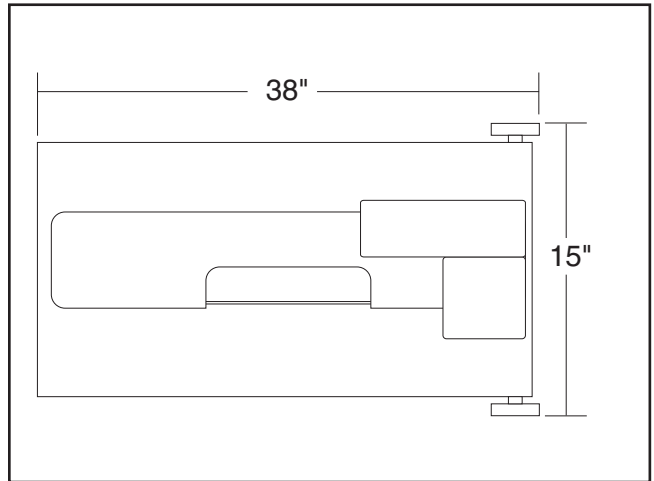


Figure 4. Minimum working clearances.

	<p>⚠️ CAUTION Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!</p>
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Stand Assembly

Components and Hardware Needed:	Qty
Bandsaw	1
Hex Bolts M6-1 x 12	8
Flat Washer 6mm	12
Hex Nuts M6-1	12
Stand Legs	2
Corner Support Braces	4
Axle	1
Wheels.....	2
Cotter Pins.....	4
Transport Handle.....	1
Wheel Mounting Bracket	1
Hex Bolts M8-1.25 x 20	6
Hex Nuts M8-1.25	6
Flat Washers 8mm	6
Tool Tray	1
Phillips Head Screws M6-1 x 12	4

To assemble the stand:

1. Unfold the two stand leg assemblies. They are hinged on the edges for easy set up.
2. Using the M6-1 hex nuts, hex bolts and flat washers, install the corner support braces in the bottom corners of the leg assemblies (**Figure 5**).
3. On one of the leg assemblies, attach the wheel mounting bracket along with the corner support braces to the outside bottom edge as shown in **Figure 5**.

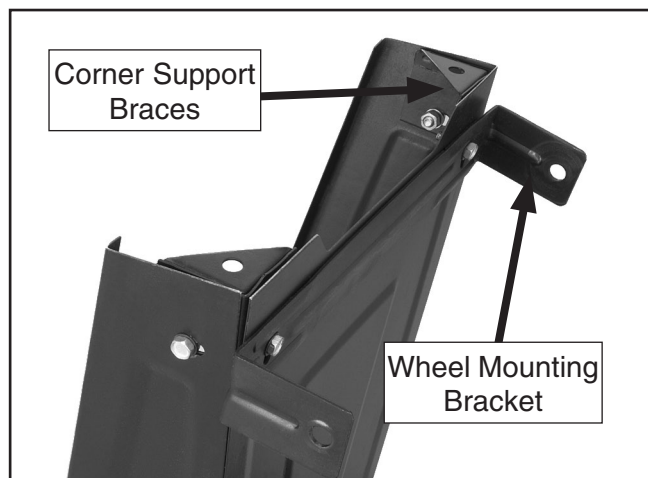


Figure 5. Corner braces and wheel bracket.

4. Slide the axle through the holes in the mounting bracket on the bottom edge of the stand.
5. Slide the wheels onto the axle on the outside of the mounting brackets, and secure with the cotter pins as shown in **Figure 6**.

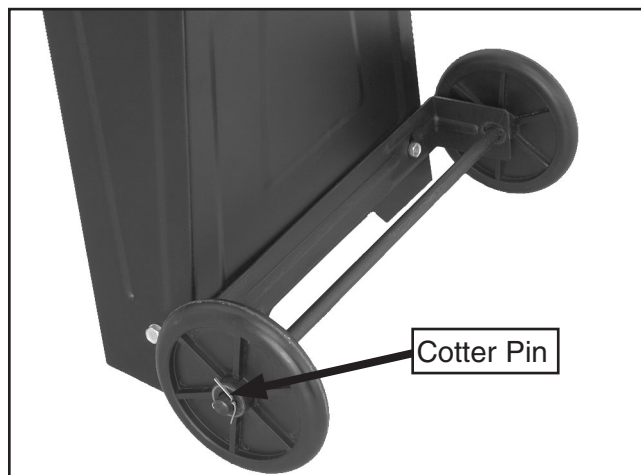


Figure 6. Wheel assembly.

6. On the other leg, Insert the handle into the pre-drilled holes and secure with the cotter pins (see **Figure 7**).

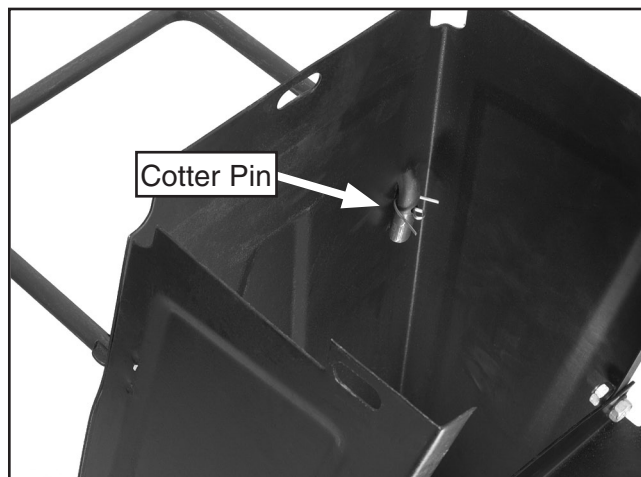


Figure 7. Cotter pins installed into the handle.



7. With the help of an assistant, lift the bandsaw onto a pair of closely spaced sawhorses or other suitable support (see **Figure 8**).

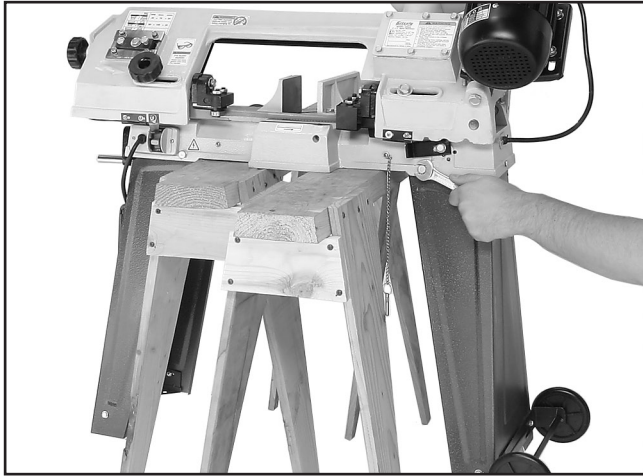


Figure 8. Leg assembly.

8. Attach the legs to the bandsaw with the M8-1.25 x 20 hex bolts, flat washers, and hex nuts.

Note: At this time, tighten with a 14mm wrench or socket just enough to secure the parts. Final tightening will take place when the stand is fully assembled.

9. Remove the sawhorses and install the tool tray in the middle of the stand as shown in **Figure 9** with M6-1 Phillips head screws, flat washers and hex nuts.



Figure 9. Tool tray.

10. Check to see if the bandsaw is relatively level then final tighten all the nuts.

Installing Pulleys

The V-belt drive system for the bandsaw requires the installation of two pulleys. The pulleys are covered for operator safety and to keep the V-belt and pulleys clean.

Components and Hardware Needed:	Qty
Pulley Cover	1
Pulleys & Keys.....	2
Phillips Head Screws M6-1 x 25 (installed).....	2
Flat Washers 6mm (installed).....	2

To install the pulley cover:

1. KEEP BANDSAW UNPLUGGED!
2. Place the pulley cover over the motor and gear shafts, and secure with the (already installed) M6-1 x 12 Phillips head screws and flat washers as shown in **Figure 10**.



Figure 10. Installing pulley cover.



To install the pulleys:

1. Open pulley cover.
2. Insert the woodruff keys into the slots on the shafts.
3. Slide the large diameter motor pulley onto the motor shaft, closest (**Figure 11**).

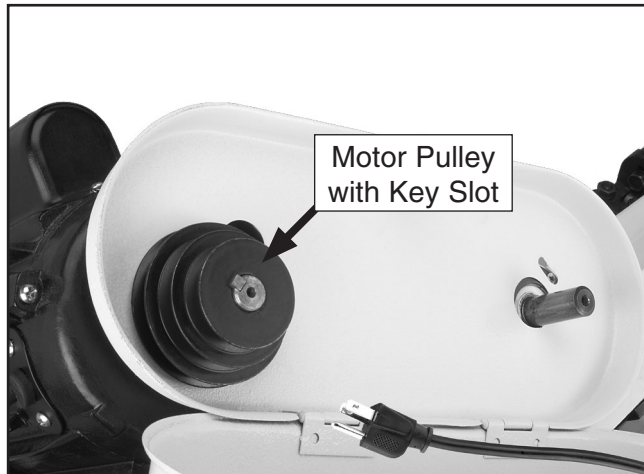


Figure 11. Installing motor pulley.

3. Install the worm gear pulley with the small diameter wheel closest to the gear box.
4. Use a straightedge to check the alignment of the pulley wheels as shown in **Figure 12**.



Figure 12. Checking pulley alignment.

5. When the pulley wheels are aligned, tighten the setscrews on both pulleys.

Installing V-Belt

To install the V-belt around the pulleys:

1. **KEEP BANDSAW UNPLUGGED!**
2. Unthread the motor lock bolt to allow the motor to pivot up.
3. Open the pulley cover door and pivot the motor up to allow the V-belt to slide into the pulley grooves as shown in **Figure 13**.



Figure 13. V-belt installation.

4. Release the motor, letting the weight tension the V-belt, and thread the motor lock bolt against the side of the bandsaw.



Installing Work Stop

The work stop is designed to provide the operator a quick reference for making multiple cuts at the same length.

To install the work stop onto the bandsaw:

1. KEEP BANDSAW UNPLUGGED!
2. Install the work stop shaft into the side of the bandsaw then lock it in place by tightening the setscrew (see **Figure 14**).



Figure 14. Installing work stop shaft.

3. Slide the work stop onto the end of the shaft and lock it into position with the locking lever shown in **Figure 15**.

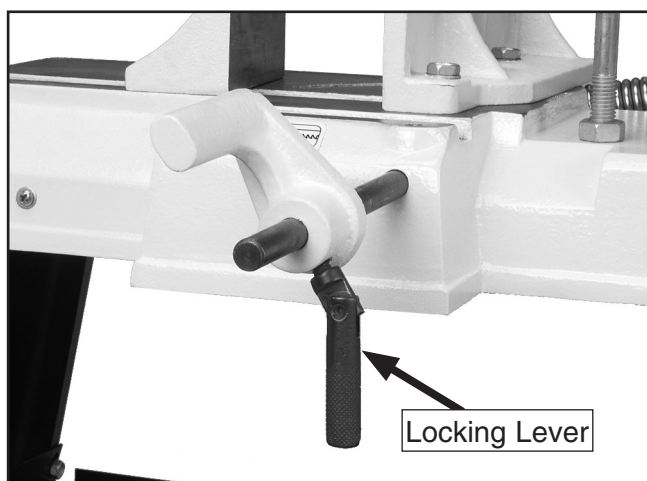


Figure 15. Work stop locking lever.

Vertical Assembly

The Model G0622 can easily be set up for vertical cutting operations.

Components and Hardware Needed:	Qty
Table.....	1
Table Bracket	1
Flat Head Screw 1/4"-20 x 1/2"	1
Switch Safety Bracket	1
Hex Nut 1/4"-20	1

To assemble the bandsaw for vertical cutting:

1. Remove the two flat head screws and the blade guide cover shown in **Figure 16**.

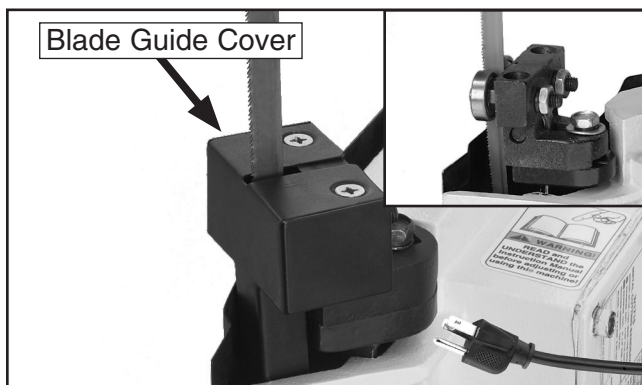


Figure 16. Blade guide cover.

2. Install the table and replace the two screws removed in **Step 1**.
3. Install the table bracket shown in **Figure 17** with the bolt (already in the casting), the flat head screw, and the hex nut.

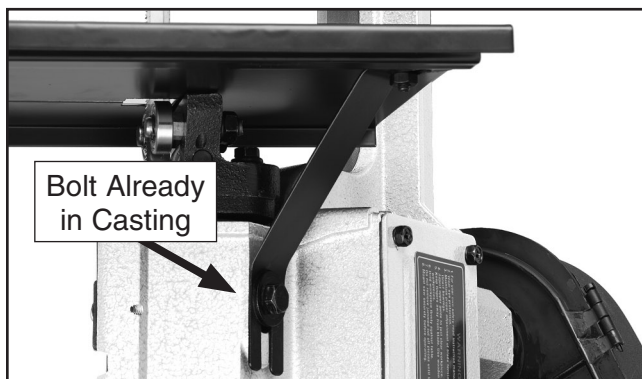


Figure 17. Table and bracket installed.



5. Place a level on the table, as shown in **Figure 18**, and adjust the adjustment bolt shown in **Figure 19** until the table is level.



Figure 18. Adjusting table level.



Figure 19. Adjustment bolt.

6. Install the safety bracket and lock in place with the pin shown in **Figure 20** to keep the saw from falling.

Note: To ensure the safety bracket fits securely in the notch on the body frame, the safety bracket may need to be slightly "modified" with a hammer or other appropriate implement to fit securely.

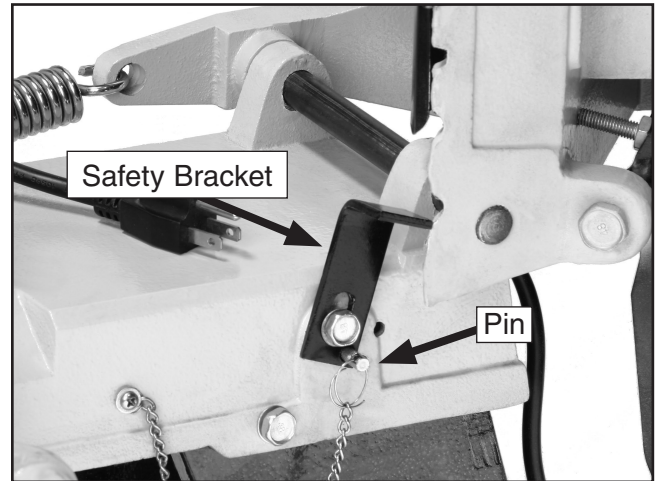
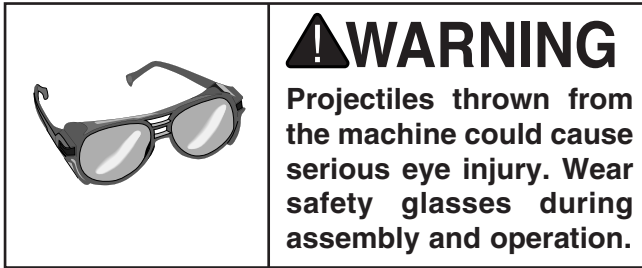


Figure 20. Safety bracket.



Test Run



WARNING
Projectiles thrown from the machine could cause serious eye injury. Wear safety glasses during assembly and operation.

Starting the machine:

1. Read the entire instruction manual.
2. Make sure all tools and foreign objects have been removed from the machine.
3. Connect the bandsaw to power.
4. Put on safety glasses and secure loose clothing or long hair.
5. Raise the bandsaw by the handle.
6. Start the bandsaw while keeping your finger near the ON/OFF switch at all times during the test run (**Figure 21**). The bandsaw should run smoothly with little or no vibration.

—If you suspect any problems, immediately stop the bandsaw and correct before continuing.

—If you need any help with your bandsaw call our Tech Support at (570) 546-9663.



Figure 21. ON/OFF switch.

Recommended Adjustments

The adjustments listed below have been performed at the factory. However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the adjustments remain unchanged.

Step-by-step instructions on verifying these adjustments can be found in **SECTION 7: SERVICE ADJUSTMENTS**.

Factory adjustments that should be verified:

1. Blade Tracking (**Page 31**).
2. Squaring the Blade (**Page 32**).
3. Blade Guide Bearings (**Page 33**).

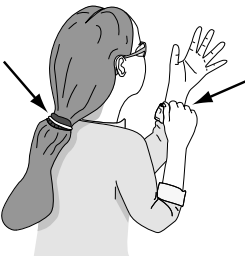
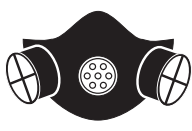


SECTION 4: OPERATIONS

Operation Safety

⚠️ WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



⚠️ WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

⚠️ WARNING

Electrocution Hazard. The motor and switch on this bandsaw are not protected against liquids. Do not use cutting fluids with this bandsaw. Serious injury could occur.

Vise

⚠️ CAUTION

Always turn the saw *OFF* and allow the blade to come to a complete stop before using the vise! Failure to follow this caution may lead to injury.

The vise can hold material up to six inches wide and be set to cut angles from 0 to 45 degrees.

To adjust the angle on the vise:

1. Loosen the lock nut with a 12mm hex wrench or socket as shown in **Figure 22**.
2. Use the scale as a guide to set your angle or use a machinist square to square the blade to the vise as shown in **Figure 23**.
3. Tighten the lock nut.

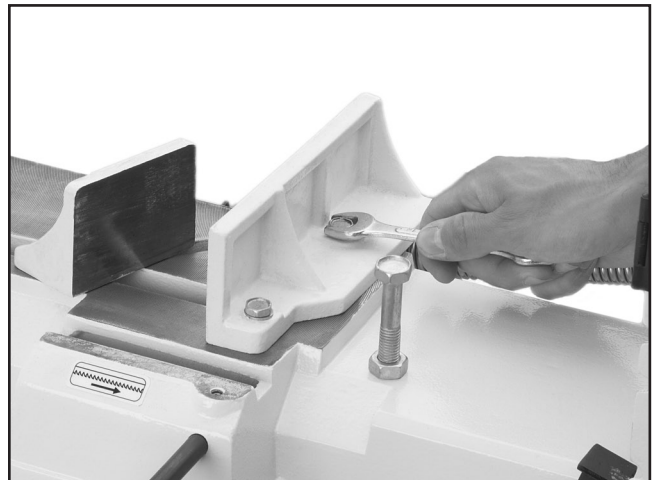


Figure 22. Setting vise angle.



Blade Speed

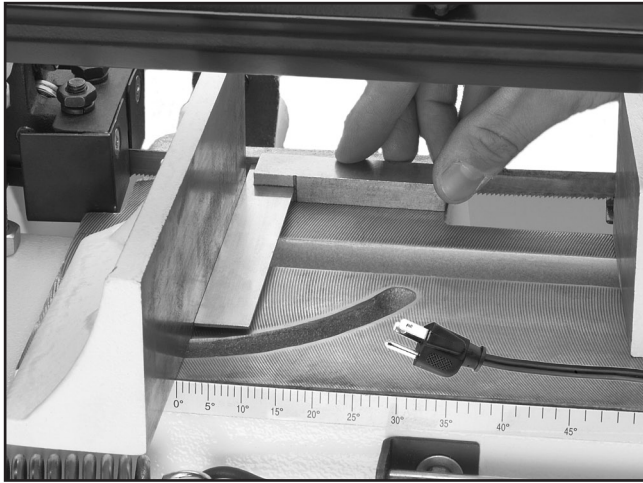


Figure 23. Squaring vise to blade.

4. Loosen the lock nut on the opposite jaw so the jaw can float, and match the angle of the workpiece.
5. Tighten the vise against the workpiece.

Note: *Figure 24 shows correct methods of holding different workpiece shapes.*

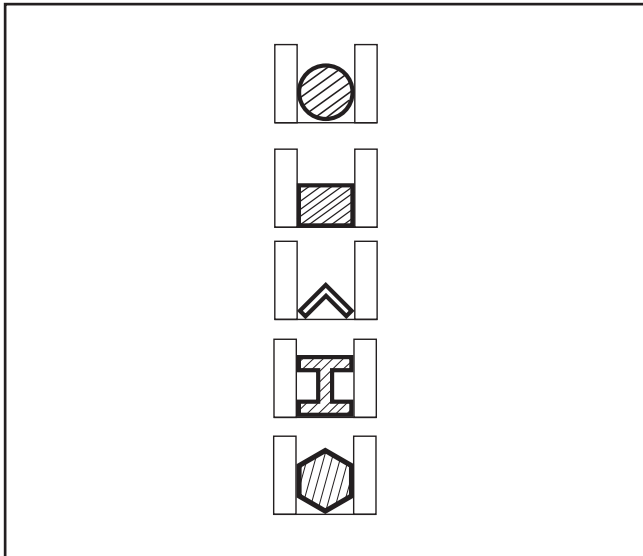


Figure 24. Workholding options by material shape.

The bandsaw is capable of operating at 78, 108, or 180 FPM. The speed can easily be adjusted by changing the V-belt placement. **Figure 25** shows an illustration of each pulley to belt combination, and the following list provides the blade speeds in feet per minute.

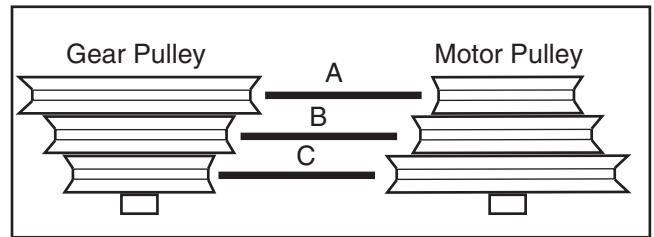


Figure 25. Pulley & V-belt configuration.

Belt Position	Blade Speed
A.....	78 FPM
B.....	108 FPM
C.....	180 FPM

Continued on next page →



To change the blade speeds:

1. UNPLUG THE BANDSAW!
2. Loosen the motor tension bolt to allow the motor to pivot (**Figure 26**).

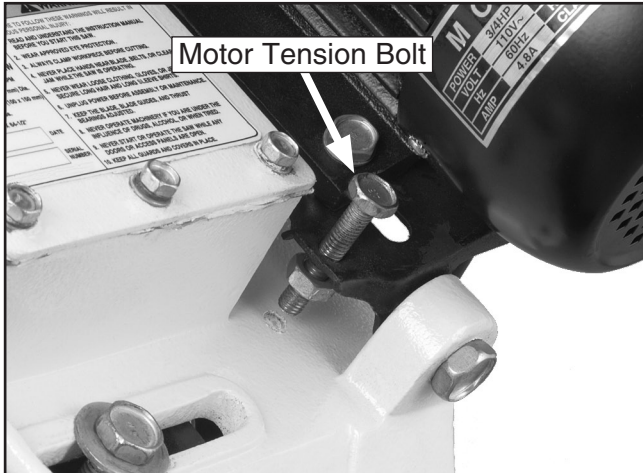


Figure 26. Motor tension bolt.

3. Raise the motor to relieve the belt tension and position the belt in the desired pulley alignment.
4. Release the motor and let the motor weight tension the belt.
5. Tighten the motor tension bolt back against the frame of the bandsaw.

Blade Selection

When selecting blades, keep in mind that the Model G0622 accepts only 1/2" x 0.028 x 64 1/2" blades.

When deciding which type of blade to use, consider the type and thickness of material being cut. Refer to **Figure 27** for recommended blade tooth (TPI) and speed (FPM) based on the workpiece material. The blade must have at least three teeth in contact with the workpiece.

Example: 24 TPI blade minimum workpiece thickness is .125" or (3/TPI). The teeth can strip off the blade if fewer than three teeth are in contact with the material.

Material	TPI	FPM
Tool Steel Stainless Steel Bearing Bronze	24	78
Mild Steel Hard Brass Bronze	18	108
Soft Brass Aluminum Other Light Metals	14	180

Figure 27. Model G0622 Blade chart.



Blade Guides

The blade guides should be as close to the workpiece as possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off the cut line.

To adjust the blade guides:

1. Loosen the knob shown in **Figure 28** and slide the blade guide as close to the workpiece as possible, then tighten the knob.

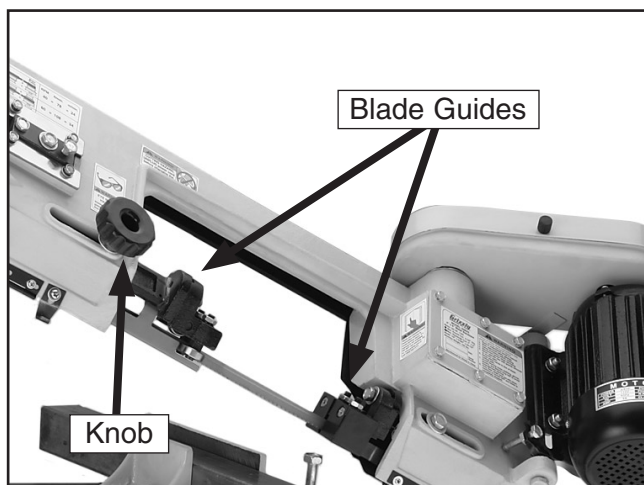


Figure 28. Blade guides.

Feed Rate

The feed rate is controlled by the spring and handle shown in **Figure 29**.

To adjust the feed rate:

Slower: Twist the handle clockwise to add tension to the spring.

Faster: Twist the handle counterclockwise to remove tension from the spring.

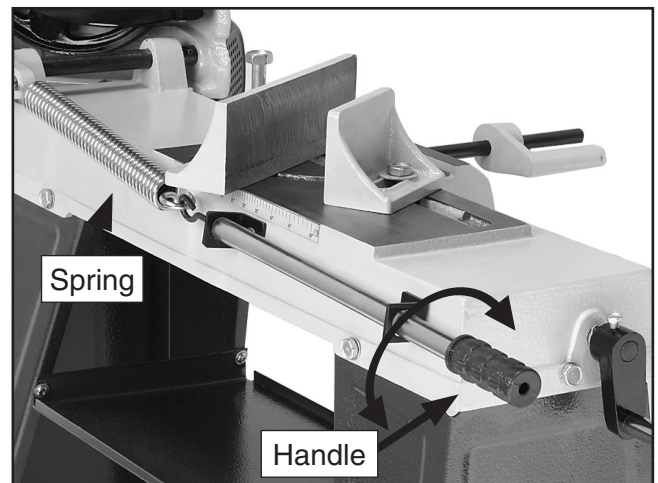


Figure 29. Feed rate adjustment.



Operation Tips

The following tips will help you safely and effectively operate your bandsaw and help you get the maximum life out of your saw blades.

Tips for horizontal cutting:

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length (see **Figure 30**).
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material.
- Let the blade reach full speed before engaging the workpiece. Never start a cut with the blade in contact with the workpiece (see **Figure 31**).
- Chips should be curled and silvery. If the chips are thin and powder like, increase your feed rate.
- If the chips are burned, reduce the blade speed.
- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!

Tips for vertical cutting:

- Make sure that the vertical table assembly is securely fastened to the bandsaw frame so it will adequately support the workpiece.
- Always keep your fingers away from the blade and always hold the workpiece securely in your hand (**Figure 32**).
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.

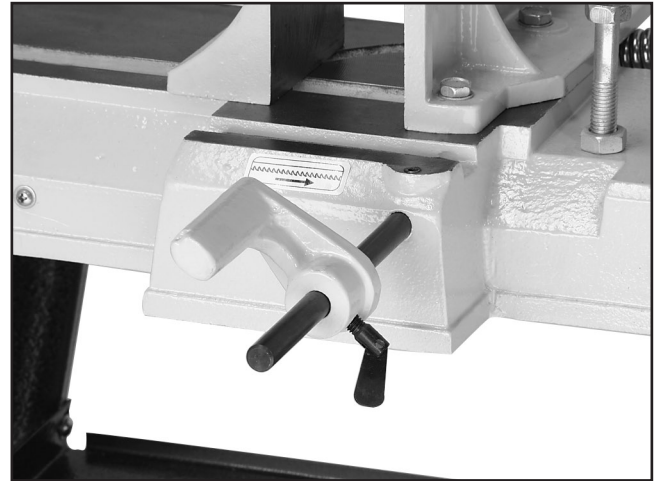


Figure 30. Work stop.

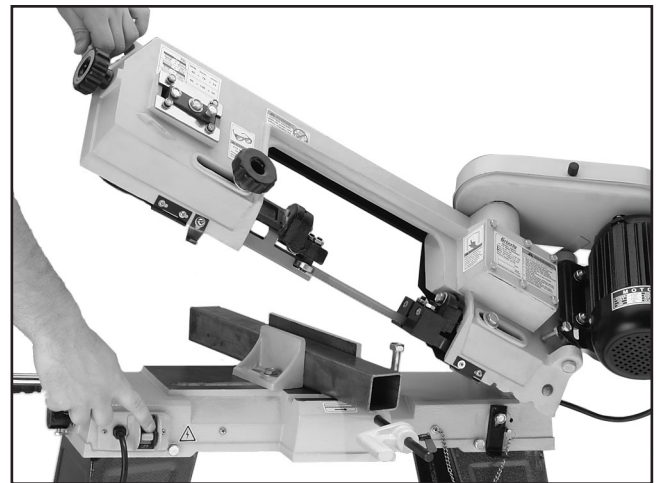


Figure 31. Proper starting position.

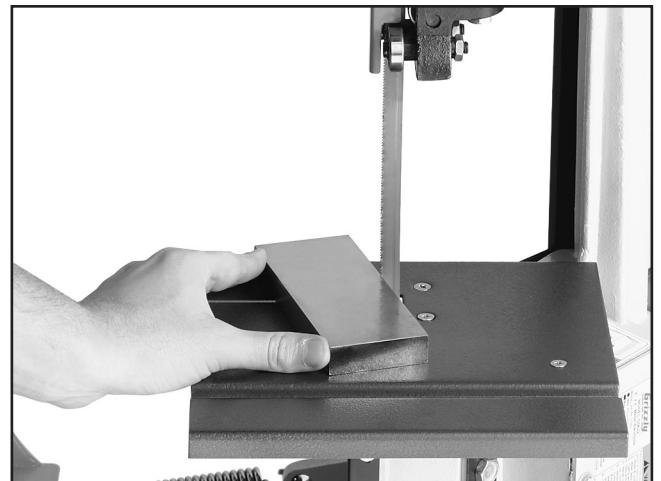


Figure 32. Using the vertical set-up.

NOTICE

Loosen blade tension at the end of each day to prolong blade life.



SECTION 5: ACCESSORIES

- G5107—64 ½ x ½ x .025 10 TPI Raker
- G5108—64 ½ x ½ x .025 14 TPI Raker
- G5109—64 ½ x ½ x .025 18 TPI Raker
- G5110—64 ½ x ½ x .025 24 TPI Raker
- G5111—64 ½ x ½ x .025 6-10 Variable Pitch
- G5112—64 ½ x ½ x .025 8-12 Variable Pitch
- G5113—64 ½ x ½ x .025 10-14 Variable Pitch
- G5114—64 ½ x ½ x .025 14-18 Variable Pitch
- G5115—64 ½ x ½ x .025 20-24 Variable Pitch

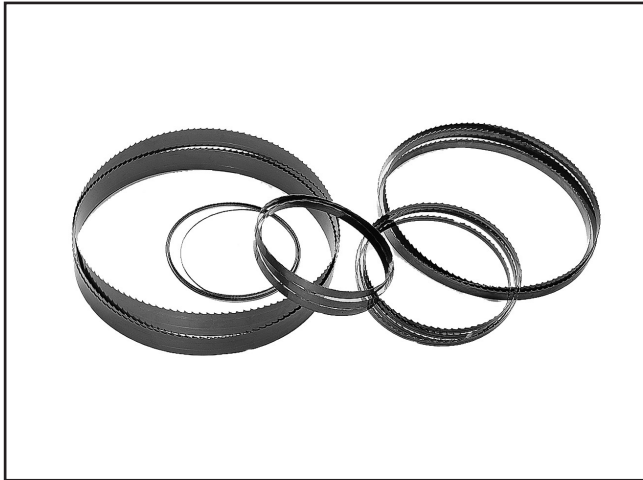


Figure 33. Blades

Call 1-800-523-4777 To Order

H5405—Lenox® Lube Tube™

Lenox® Lube Tube™ is a stick lubricant designed to prevent heat buildup. Apply it directly to the blade to improve overall blade life and productivity. Can be used on ferrous and non-ferrous metals. Biodegradable, non-toxic, and non-staining 14.5 oz tube.



Figure 34. Lenox® Lube Tube™.

H5408—Blade Tensioning Gauge

The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.



Figure 35. H5408 Blade Tensioning Gauge.



- G5618—Deburring Tool w/2 Blades**
- G5619—Extra Aluminum Blades**
- G5620—Extra Brass and Cast Iron Blade**

The quickest tool for smoothing freshly machined metal edges. Comes with two blades, one for steel and aluminum and one for brass and cast iron.



Figure 36. G5618 Deburring tool.

- G7984—Face Shield**
- H1298—Dust Sealed Safety Glasses**
- H1300—UV Blocking, Clear Safety Glasses**
- H2347—Uvex® Spitfire Safety Glasses**
- H0736—Shop Fox® Safety Glasses**

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!

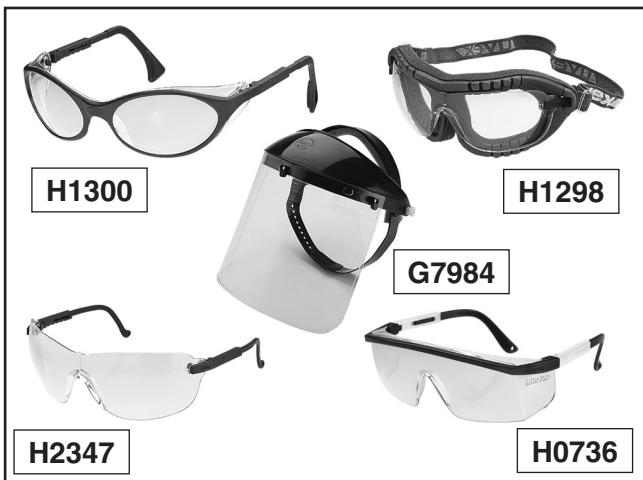


Figure 37. Our most popular safety glasses.

- H1302—Standard Earmuffs**
 - H4979—Deluxe Twin Cup Hearing Protector**
 - H4977—Work-Tunes Radio Headset Earmuffs**
- Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.



Figure 38. Our most popular earmuffs.

- G9256—6" Dial Caliper**
- G9257—8" Dial Caliper**
- G9258—12" Dial Caliper**

These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display.

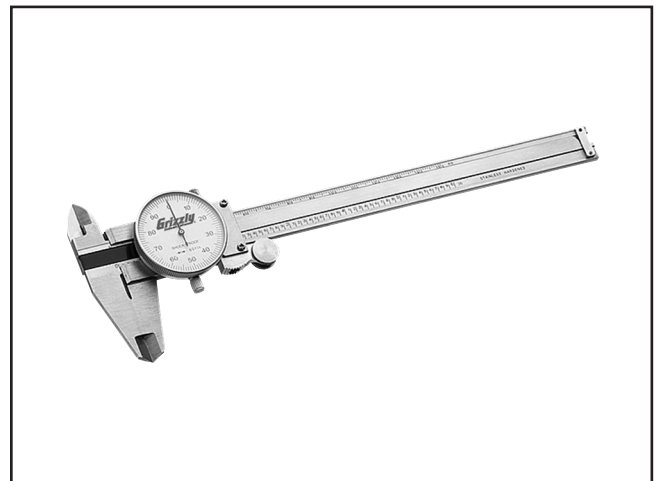
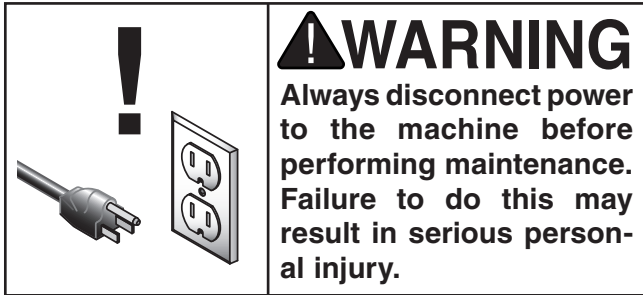


Figure 39. Grizzly® Dial Calipers.

Call 1-800-523-4777 To Order



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.
- Clean after each use.

Monthly Check:

- V-belt tension, damage, or wear.
- Lubricate vise screw.

Annual Check:

- Lubricate gear box.

Cleaning

Cleaning the Model G0622 is relatively easy. After using your bandsaw, remove excess chips by sweeping. Then send chips for recycling.

Lubrication

Before applying lubricant to any area, wipe the area clean to avoid contamination. Lubricate the vise screw shown in **Figure 40** with general purpose grease.

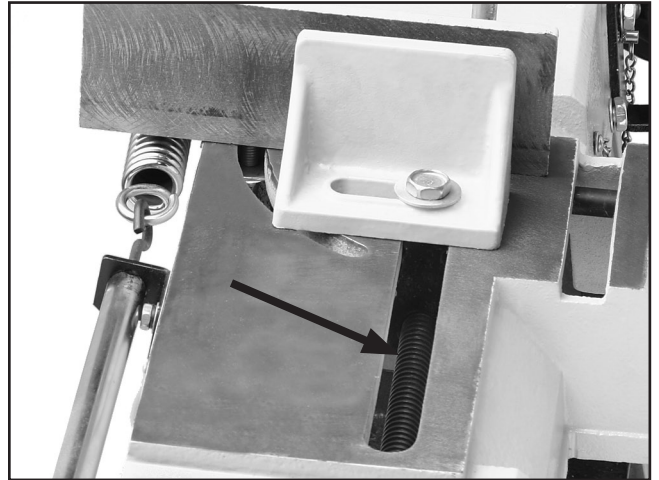


Figure 40. Location to lubricate vise screw.

Remove the cover on the gear box in **Figure 41** and coat the gears with general purpose grease.

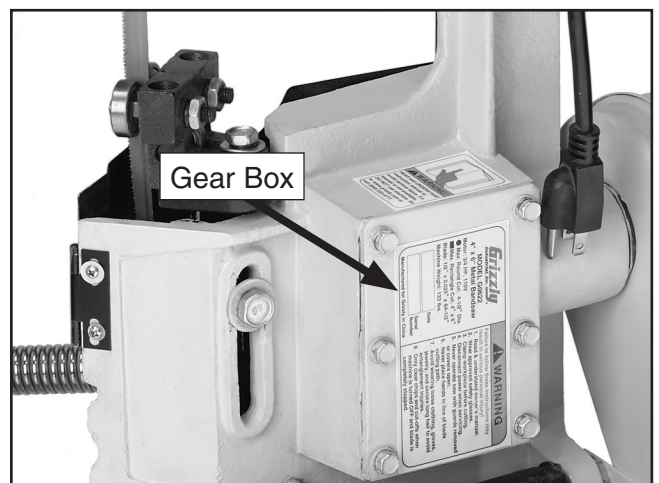


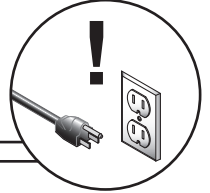
Figure 41. Gear box location.



SECTION 7: SERVICE

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If you need help troubleshooting, you need replacement parts, or you are unsure of how to perform the procedures in this section, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Plug/receptacle is at fault or wired incorrectly. 2. Start capacitor is at fault. 3. Motor connection wired incorrectly. 4. Power supply is at fault/switched OFF. 5. ON/OFF switch is at fault. 6. Wiring is open/has high resistance. 7. Motor is at fault. 	<ol style="list-style-type: none"> 1. Test for good contact or correct the wiring. 2. Test/replace if faulty. 3. Correct motor wiring connections. 4. Make sure all hot lines/grounds are operational and have correct voltage on all legs. 5. Replace faulty ON button or ON/OFF switch. 6. Troubleshoot wires for internal/external breaks; check for disconnected/corroded connections; repair/replace wiring. 7. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Wrong blade for the workpiece material (metal). 2. Feed rate too fast for task. 3. V-belt slipping. 4. Blade is slipping on wheels. 5. Pulley/sprocket slipping on shaft. 6. Motor bearings are at fault. 7. Motor is at fault. 	<ol style="list-style-type: none"> 1. Use blade with correct properties for your type of cutting. 2. Decrease feed rate. 3. Replace bad V-belt and re-tension. 4. Adjust blade tracking and tension. 5. Replace loose pulley/shaft. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 7. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. V-belt is slapping belt cover. 2. V-belt worn or loose. 3. Pulley is loose. 	<ol style="list-style-type: none"> 1. Inspect belt cover for proper installation. 2. Inspect/replace belt with a new one. 3. Realign/replace shaft, pulley, setscrew, and key as required.



SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine is loud when cutting or bogs down in the cut.	<ol style="list-style-type: none"> 1. Excessive feed rate. 2. The blade TPI is too great, or the material is too coarse. 	<ol style="list-style-type: none"> 1. Refer to Feed Rate on Page 23, or Blade Speed on Page 22 and adjust as required. 2. Refer to Blade Selection on Page 22 and adjust as required.
Blades break often.	<ol style="list-style-type: none"> 1. The workpiece is loose in the vise. 2. The feed or cut speed is wrong. 3. The blade TPI is too great, or the material is too coarse. 4. The blade is rubbing on the wheel flange. 5. The bandsaw is being started with the blade resting on the workpiece. 6. The guide bearings are misaligned, or the blade is rubbing on the wheel flange. 7. The blade is too thick, or the blades are of low quality. 	<ol style="list-style-type: none"> 1. Clamp the workpiece tighter, or use a jig to hold the workpiece. 2. Refer to Feed Rate on Page 23, or Blade Speed on Page 22 and adjust as required. 3. Refer to Blade Selection on Page 22 and adjust as required. 4. Refer to Blade Tracking on Page 31, and adjust as required. 5. Start bandsaw and then slowly lower the headstock by setting the feed rate. 6. Refer to Blade Tracking on Page 31, or Blade Guides on Page 23, and adjust as required. 7. Use a higher quality blade.
Blade dulls prematurely.	<ol style="list-style-type: none"> 1. The cutting speed is too fast. 2. The blade TPI is too coarse. 3. The blade feed pressure is too light. 4. The workpiece has hard spots, welds, or scale is on the material. 5. The blade is twisted. 6. The blade is slipping on the wheels. 	<ol style="list-style-type: none"> 1. Refer to Blade Speed on Page 22 and adjust as required. 2. Refer to Blade Selection on Page 22 and adjust as required. 3. Refer to Feed Rate on Page 23, and adjust as required. 4. Increase the feed pressure, and reduce the cutting speed. 5. Replace the blade. 6. Refer to Blade Tension on Page 32, and adjust as required.
Blade wears on one side.	<ol style="list-style-type: none"> 1. The blade guides are worn or mis-adjusted. 2. The blade guide slide bracket is loose. 3. The wheels are out of alignment. 	<ol style="list-style-type: none"> 1. Refer to Blade Guides on Page 23 and replace or adjust. 2. Tighten the blade guide bracket. 3. Refer to Blade Tracking on Page 31, and adjust as required.
Teeth are ripping from the blade.	<ol style="list-style-type: none"> 1. The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece. 2. The workpiece is vibrating in the vise. 3. The blade gullets are loading up with chips. 	<ol style="list-style-type: none"> 1. Refer to Blade Selection on Page 22 and decrease the feed pressure. Refer to Feed Rate on Page 23, and adjust as required. 2. Re-clamp the workpiece in the vise, and use a jig if required. 3. Use a coarser-tooth blade.
The cuts are crooked.	<ol style="list-style-type: none"> 1. The feed pressure is too high. 2. The guide bearings are out of adjustment, or too far away from the workpiece. 3. The blade tension is low. 4. The blade is dull. 5. The blade speed is wrong. 	<ol style="list-style-type: none"> 1. Refer to Feed Rate on Page 23, and adjust as required. 2. Refer to Blade Guides on Page 23 and replace or adjust. 3. Refer to Blade Tension on Page 32, and adjust as required. 4. Refer to Blade Change on Page 30 and replace the blade. 5. Refer to Changing Blade Speed on Page 22 and adjust as required.



Blade Change

Blades should be changed when they become dull, damaged, or when you are using materials that require a blade with a certain type or tooth count.

To change the blade on the bandsaw:

1. UNPLUG THE BANDSAW!
2. Raise the head of the bandsaw to the vertical position and remove the wheel access cover.
3. Loosen the tension knob and slip the blade off of the wheels.

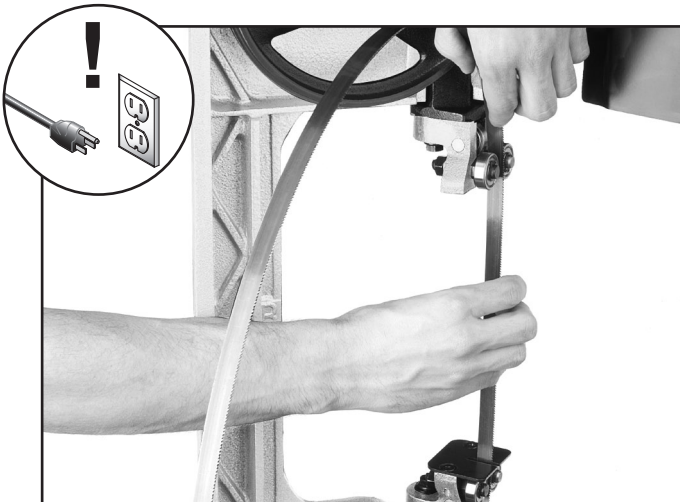


Figure 42. Installing blade.

4. Install the new blade through both blade guide bearings as shown in **Figure 42** and around the bottom wheel.
5. Hold the blade around the bottom wheel with one hand and slip it around the top wheel with the other hand, keeping the blade between the blade guide bearings.

Note: It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth are facing toward the workpiece, as shown in **Figure 43**, after mounting to the bandsaw. Some blades will have a directional arrow as a guide.

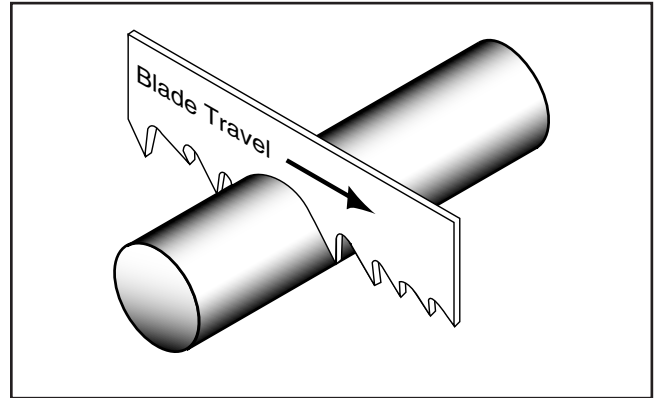


Figure 43. Blade cutting direction.

6. When the blade is around both wheels, adjust the position so the back of the blade is against the shoulder of the wheels (see **Figure 44**).
7. Tighten the tension knob so the blade will not slip on the wheels on start up.
8. Connect the bandsaw to the power source.
9. Briefly turn the bandsaw **ON** then **OFF** to position the blade and resume the previous tracking.

—If the tracking needs to be adjusted, see **Tracking** in the next section.

—If the tracking is fine, proceed to **Blade Tension** on **Page 32**.



Figure 44. Tension knob and blade.



Blade Tracking

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly.

To adjust the blade tracking on the bandsaw:

1. UNPLUG THE BANDSAW!
2. Position the bandsaw in the vertical position.
3. Open the wheel access cover.
4. Loosen, but do not remove the lower hex bolt in the blade wheel tilting mechanism (**Figure 45**).



Figure 45. Blade tracking adjustments.

5. Relax the blade tension using the blade tension knob.
6. Adjust the tracking hex bolt with an open end wrench as shown in **Figure 46**, then tighten the lower hex bolt loosened in **Step 4**.

—Tightening the tracking hex bolt will move the blade closer to the shoulder of the wheel.

—Loosening the tracking hex bolt will move the blade away from the shoulder.

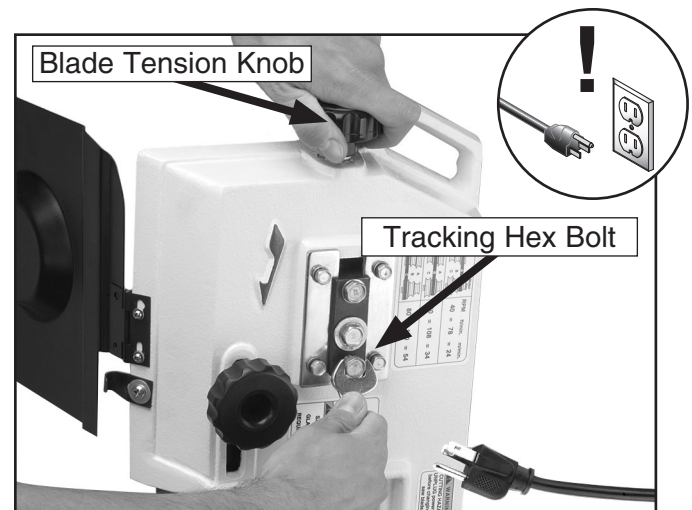


Figure 46. Adjusting tracking hex bolt.

7. Tension the blade.
8. Reconnect the power and turn **ON** the bandsaw.

—If the blade tracks along the shoulder of the wheel (without rubbing), the blade is tracking properly and this adjustment is completed.

—If the blade walks away from the shoulder of the wheel or hits the shoulder, turn **OFF** and UNPLUG the bandsaw and repeat **Steps 4-7**.

9. Turn **OFF** and UNPLUG the bandsaw and replace the blade guard and wheel access cover.



Blade Tension

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting times.

Two major signs that you do not have the correct blade tension are: 1) the blade stalls in the cut and is slipping on the wheels, and 2) the blade frequently breaks from being too loose.

To tension the blade on the bandsaw:

1. Make sure the blade is tracking properly.
2. UNPLUG THE BANDSAW!
3. Loosen and slide the blade guides as far apart as they will go then tighten them down again.
4. Turn the tension knob in **Figure 46** clockwise to tighten the blade as tight as you can get.
5. Using moderate finger pressure, push against the side of the blade. The blade should not move more than 0.004".
6. Another option is to use a blade tensioning gauge, like the one found in **ACCESSORIES** on **Page 25**. If you use this option please follow the instructions included with your gauge.

Squaring the Blade

It is always a good idea during the life of your saw to check and adjust this setting. This adjustment will improve your cutting results and extend the life of your blade.

To square the blade to the bed of the table:

1. UNPLUG THE BANDSAW!
2. Lower the head of the bandsaw all the way until it contacts the horizontal stop.
3. Place a square on the table bed and against the edge of the blade (**Figure 47**), and check different points along the length of the table between the blade guides.
4. Loosen the hex bolt shown in **Figure 47**, and rotate the seat until the blade is vertical to the bed, then tighten the hex bolt.

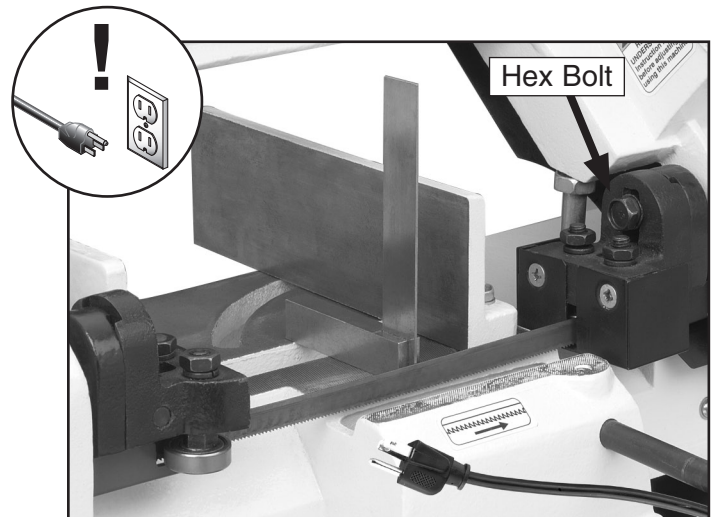


Figure 47. Squaring the blade.



Blade Guide Bearings

The blade guide bearings must be properly adjusted. One bearing on each assembly has an eccentric bushing that allows the distance between bearings to be adjusted. The bearings are secured in place by a hex nut and lock washer shown in **Figure 48**.

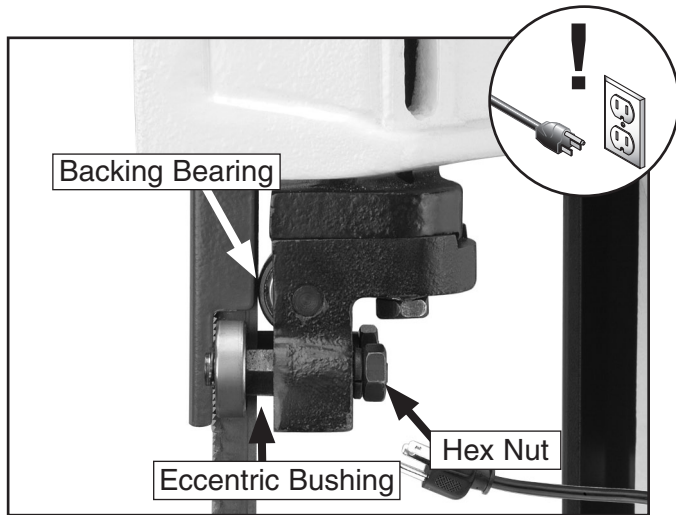


Figure 48. Blade guide adjustments.

To adjust the blade guide bearings:

1. UNPLUG THE BANDSAW!
2. Position the bandsaw in the vertical position.
3. Loosen the hex nut that secures the bearing to the eccentric bushing.
4. Using a 13mm open-end wrench, adjust the eccentric bushing position to achieve the desired clearance. The bearing and blade should have a clearance of 0.001".
5. Tighten the nut to lock the bearing in position.
6. Adjust the other eccentric blade guide bearing in the same manner. The backing bearing should have a gap between 0.002-0.003" from the back of the blade.



Electrical Components

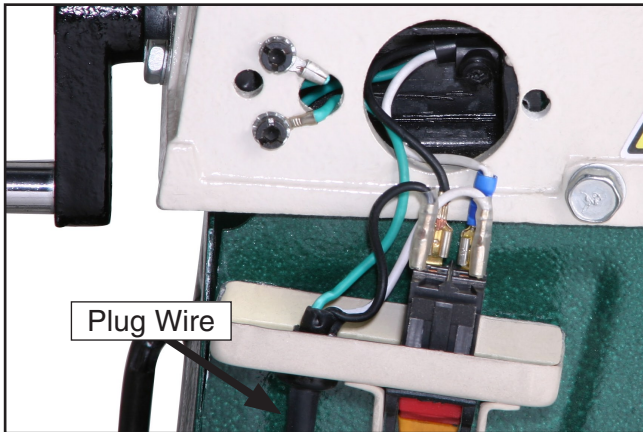


Figure 49. G0622 ON/OFF Switch.



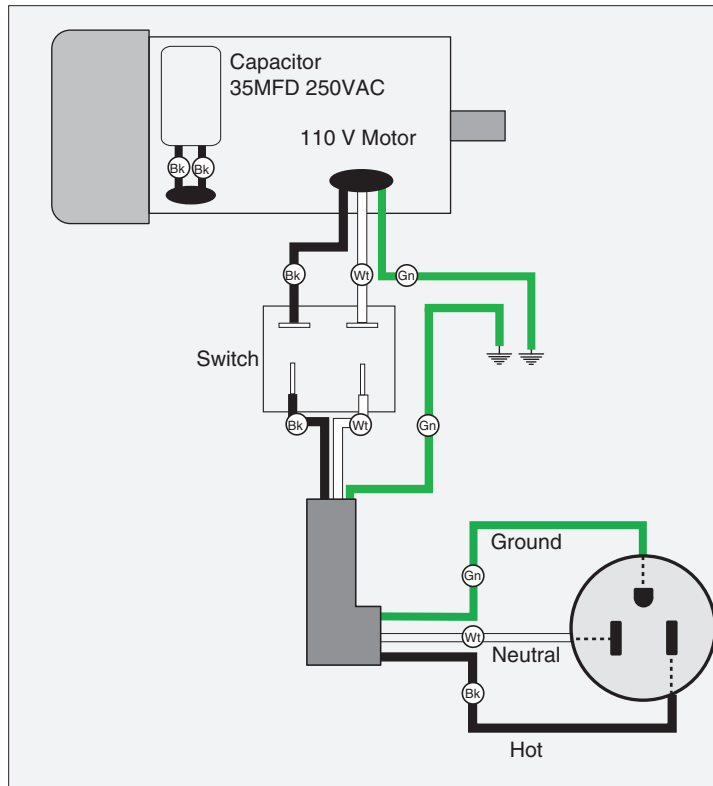
Figure 50. G0622 Capacitor.

Wiring Diagram



⚠ DANGER
 Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!

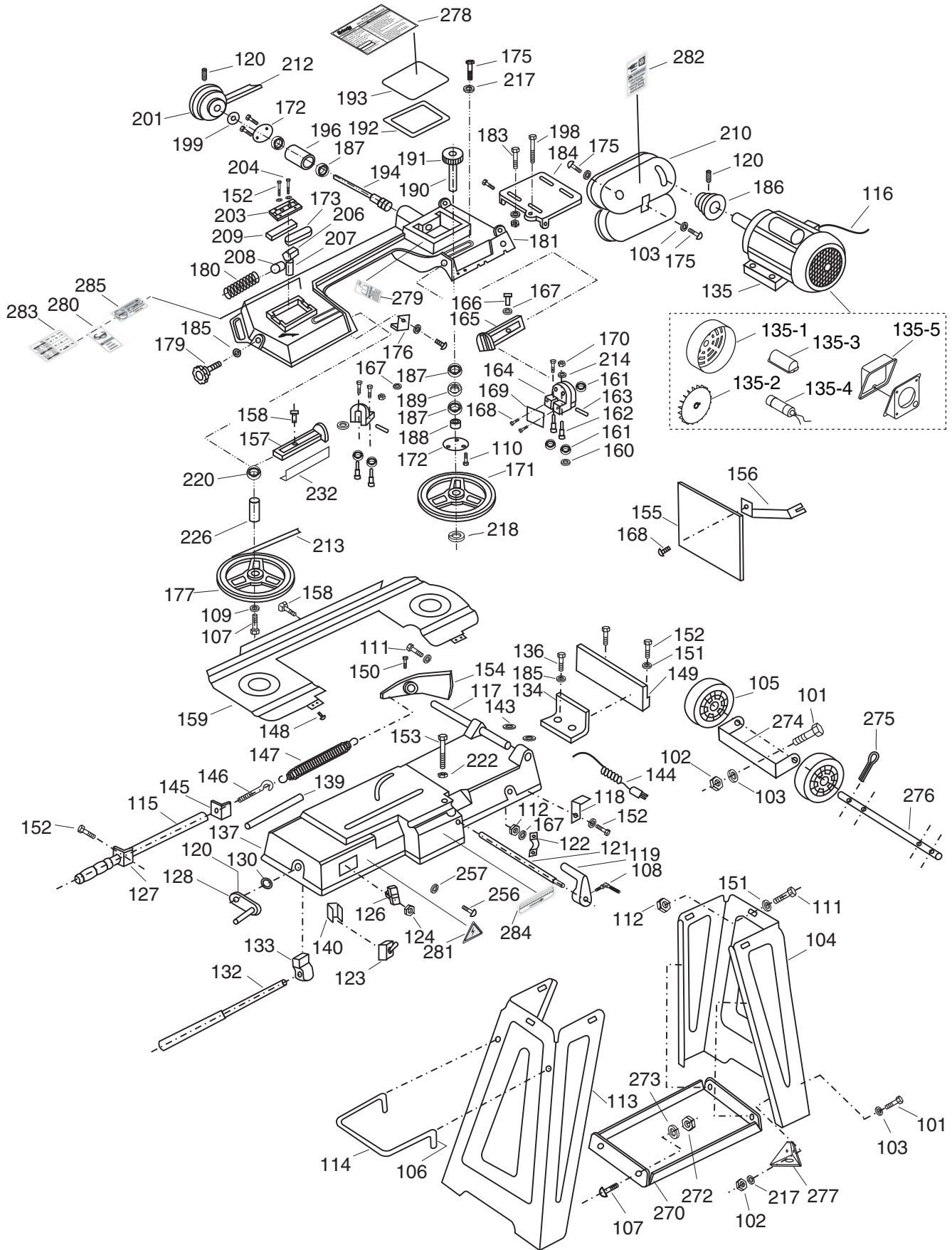
COLOR KEY	
BLACK	
WHITE	
GREEN	



5-15 Plug
 110 VAC



Parts Breakdown



Parts List

REF	PART #	DESCRIPTION
101	PB02M	HEX BOLT M6-1 X 12
102	PN01M	HEX NUT M6-1
103	PW03M	FLAT WASHER 6MM
104	P0622104	STAND LEG (RIGHT)
105	P0622105	WHEEL ASSY
106	P0622106	COTTER PIN
107	PS14M	PHLP HD SCR M6-1 X 12
108	P0622108	LOCKING LEVER
109	PW03M	FLAT WASHER 6MM
110	PFH29M	FLAT HD SCR M4-.7 X 10
111	PB20M	HEX BOLT M8-1.5 X 35
112	PN03M	HEX NUT M8-1.5
113	P0622113	STAND LEG (LEFT)
114	P0622114	TRANSPORT HANDLE
115	P0622115	ADJUSTING ROD
116	P0622116	MOTOR CORD
117	P0622117	PIVOTING ROD
118	P0622118	SUPPORT PLATE
119	P0622119	WORK STOP
120	PSS04M	SET SCREW M6-1 X 12
121	P0622121	STOCK STOP ROD
122	P0622122	WIRE RELIEF RETAINER
123	P0622123	SWITCH
124	PN06M	HEX NUT M5-.8
126	P0622126	SWITCH PANEL
127	P0622127	ADJUSTING ROD SUPPORT
128	P0622128	HAND WHEEL
130	PR47M	EXT RETAINING RING 13MM
132	P0622132	LEAD SCREW
133	P0622133	WISE NUT
134	P0622134	FRONT VISE JAW
135	P0622135	MOTOR
135-1	P0622135-1	MOTOR COVER
135-2	P0622135-2	FAN
135-3	P0622135-3	CAPACITOR COVER
135-4	P0622135-4	CAPACITOR 35MFD 250VAC
135-5	P0622135-5	JUNCTION BOX
136	PB01M	HEX BOLT M10-1.5 X 30
137	P0622137	BED
139	P0622139	SCALE
140	P0622140	ELECTRIC CORD COVER
143	P0622143	GASKET
144	P0622144	POWER CORD
145	P0622145	NUT PLATE
146	P0622146	SPRING ADJUSTING SCREW
147	P0622147	EXTENSION SPRING
148	PS38M	PHLP HD SCR M4-.7 X 10
149	P0622149	REAR VISE JAW

REF	PART #	DESCRIPTION
150	PSS14M	SET SCREW M8-1.25 X 12
151	PW01M	FLAT WASHER 8MM
152	PB09M	HEX BOLT M8-1.25 X 20
153	PB43M	HEX BOLT M12-1.75 X 75
154	P0622154	PIVOT
155	P0622155	TABLE
156	P0622156	TABLE BRACKET
157	P0622157	ADJUSTABLE BRACKET (TOP)
158	P0622158	KNOB BOLT M10-1.5 X 25
159	P0622159	BLADE BACK SAFETY COVER
160	PR39M	EXT RETAINING RING 8MM
161	P629	BALL BEARING 629ZZ
162	P0622162	GUIDE PIVOT
163	P0622163	BEARING SHAFT PIN 8X40MM
164	P0622164	BLADE ADJUSTABLE SEAT
165	P0622165	ADJUSTABLE BRACKET
166	P0622166	GUIDE BEARING LOCK
167	PLW04M	LOCK WASHER 8MM
168	PFH02M	FLAT HD SCR M6-1 X 12
169	P0622169	BLADE GUARD
170	PN03M	HEX NUT M8-1.25
171	P0622171	BLADE WHEEL (FRONT)
172	P0622172	BLADE WHEEL BEARING COVER
173	PK35M	KEY 5 X 5 X 30
175	PS14M	PHLP HD SCR M6-1 X 12
176	P0622176	SWITCH CUT OFF TIP
177	P0622177	BLADE WHEEL (REAR)
179	P0622179	BLADE TENSION KNOB
180	P0622180	COMPRESSION SPRING
181	P0622181	BODY FRAME
183	PB07M	HEX BOLT M8-1.25 X 25
184	P0622184	MOTOR MOUNT PLATE
185	PW04M	FLAT WASHER 10MM
186	P0622186	MOTOR PULLEY
187	P0622187	BALL BEARING
188	P0622188	BEARING BUSHING
189	P0622189	OIL SEAL
190	P0622190	TRANSMISSION WHEEL SHAFT
191	P0622191	TRANSMISSION GEAR
192	P0622192	GEAR BOX GASKET
193	P0622193	GEAR BOX COVER
194	P0622194	WORM GEAR
196	P0622196	BEARING BUSHING
198	PB22M	HEX BOLT M8-1.25 X 50
199	P0622199	BUSHING
201	P0622201	WORM GEAR PULLEY
203	P0622203	BLADE TENSION PLATE
204	PB20M	HEX BOLT M8-1.25 X 35



Parts List

REF	PART #	DESCRIPTION
206	P0622206	SLIDING PLATE DRAW BLOCK
207	P0622207	BLADE WHEEL SHAFT
208	P0622208	SHAFT BLOCK
209	P0622209	BLADE TENSION SLIDING GUIDES
210	P0622210	MOTOR PULLEY COVER
212	P0622212	V-BELT O-508
213	P0622213	BLADE 1/2 X .028 X 64 1/2
214	PW01M	FLAT WASHER 8MM
217	PW03M	FLAT WASHER 6MM
218	PR05M	EXT RETAINING RING 15MM
220	P0622220	BALL BEARING
222	PN09M	HEX NUT M12-1.75
226	P0622226	BUSHING
232	P0622232	BLADE SAFE GUARD
256	PS22M	PHLP HD SCR M5-.8 X 25
257	PLW01M	LOCK WASHER 5MM

REF	PART #	DESCRIPTION
270	P0622270	TOOL PLATE
272	PN01M	HEX NUT M6-1
273	PW03M	FLAT WASHER 6MM
274	P0622274	WHEEL STAND
275	P0622275	COTTER PIN
276	P0622276	AXLE
277	P0622277	CORNER BRACKET
278	P0622278	MACHINE ID LABEL
279	P0622279	READ MANUAL LABEL
280	P0622280	SAFETY GLASSES LABEL
281	P0622281	ELECTRICITY LABEL
282	P0622282	UNPLUG MACHINE LABEL
283	P0622283	RPM LABEL
284	P0622284	BLADE TRAVEL LABEL
285	P0622285	BLADE SAFETY LABEL

WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.



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<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
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<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
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<input type="checkbox"/> Modeltec	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
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 50-59 60-69 70+

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